

Date: Monday, 2/11/2008 2:11:54 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 37326		
Estimate Number	: 10101		
P.O. Number	:	Part Number	: D2011101
This Issue	: 2/11/2008 S.O. No. :	Drawing Number	: D2011 REV. F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 35536	Material	:
Written By	:	Due Date	: 2/25/2008 Qty: 50 Um: Each
Checked & Approved By	: <u>2080211</u>		
Comment	: Est: J 04.09.15 Added Steps 5-7 KJ/JLM		
	: Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5676
Purchase Grote Mirror P/N: 28043
Possible supplier: UAP/NAPA
Material release note required

208/02/12

(50)

2.0	28043	MIRROR 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

10 8/2/15 50

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5 08/2/15 (450)

5.0	D30141	Locknut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
Locknut

Pick:
Qty Part Number Description Batch
1 D3014-1 Lock nut

1318605 8/3/15 50 (50x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:11:54 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 37326

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

M106785

8/3/3 50

(50x)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch

9ml N/A

Sikaflex-291/-241

Batch

M105585

Expiry date

07/2008

Start: 08/03/04 Time: 10:45

Finish: 08/03/04 Time: 16:30

X80
ml 08/03/04

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

50lbs (50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5T227

1- 8/3/06 (50)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/03/06

Job Completion



2008/3/06

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

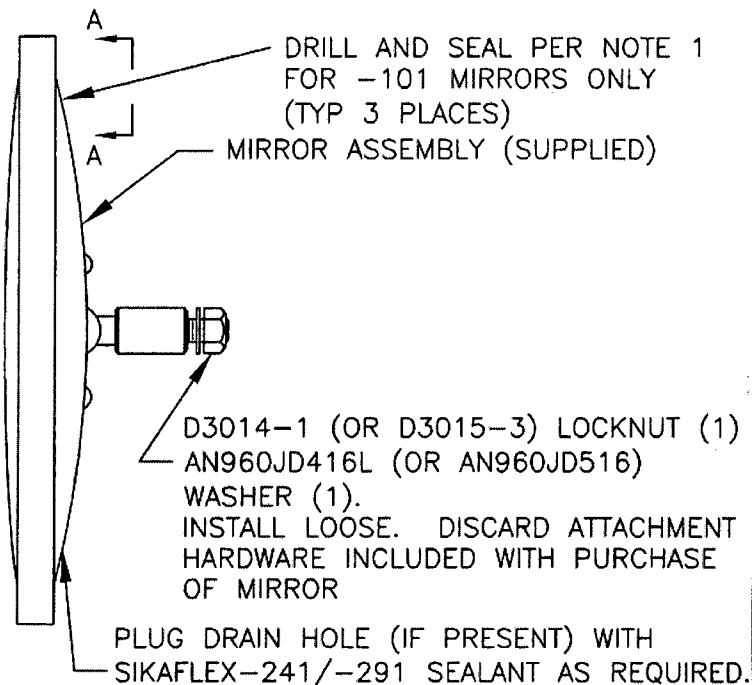
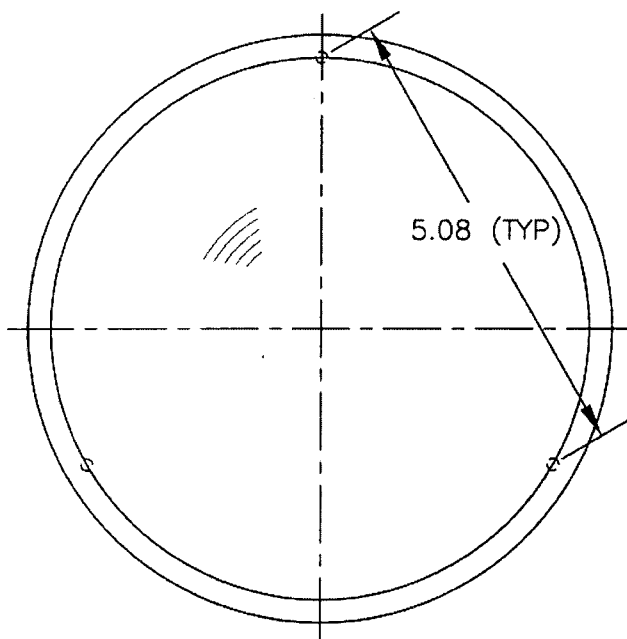
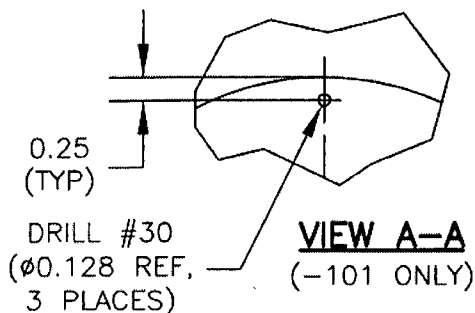
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10	TITLE MIRROR ASSEMBLY		SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



RELEASED
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

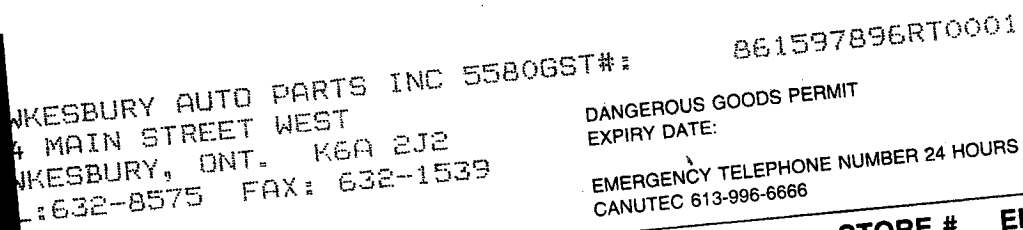
NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37326

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DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

NAPA		HAWKESBURY, ONT. :632-8575 FAX: 632-1539		EMERGENCY TELEPHONE NUMBER 24 HRS CANUTEC 613-996-6666		
ACCT #	SOLD TO	DATE	TIME	STORE #	EMP # INVOICE NO.	
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	2/15/08	13:36	060004074	31 190025	
SR #		PURCHASE ORDER #		ATTENTION		
40		5676				
AD		TAX EXEMPTION: 6122-5207				
13		TERMS: NET 30 DAYS		CHARGE SALE		
		DELIVERY:				
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
28043	GRO	GROTE	50.00 ✓	41.140	16.820	841.00 T15
<u>END PASSANT</u>		<i>S. Quinn</i>				
REFUNDED BY _____			Subtotal		841.00	
			Tax 5% GST ONLY		42.00	
			Tax 0%		0.00	

REFUNDED BY _____

VERIFIED BY _____

Subtotal
Tax 5% GST ONLY
Tax 0%

B41.00
42.00
0.00

SIGNATURE
ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL -----> CHARGE SALE 883.1